

[illegible]

Page 1

**Accept**

\_\_\_\_\_

**Setup Start**

**Stop**

**RESEARCH DESIGN AND METHODS**

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

### Process Plan:

Date: 11-06-28

### Tooling:

**Date:**




**Stop**

**QC:**

Date:

**SPC (Y/N):**

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2940	Revision Nbr <i>ECN 11.604 W</i>							
100  HAAS I HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1  <b>Memo</b> 1- Machine as per Folio FA079 □2- Tumble & Deburr	0.00 <i>[Signature] B.A. 11/08/17</i>			<u>20</u>	<u>0</u>		
110  QC Quality Control	QC1- Inspect dimensions to dimension sheet  <b>Memo</b>	0.00 <i>[Signature] B.A. 11/08/17</i>  0.00			<u>20</u>	<u>0</u>		
120  QC Quality Control	QC8- Inspect parts - second check  <b>Memo</b>	0.00 <i>[Signature]</i>  0.00		<i>11-08-23</i>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71308

Tuesday, June 28, 2011 8:17:23 AM



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Item ID: D2940-1

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Support

Start Date: 6/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

\*\*\*\*\*Mask Inside Surface as per Dwg D2940\*\*\*\*\*☐START

NME: ☐OVEN TEMPERATURE:

☐FINISH TIME:

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

150



SprayPaint

Spray Painting

SprayPaint

0.00

Memo

0.00

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

ET 11 08 24

W 301 2216 sa drwg Rev. C  
CAN 11-614

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71308

Tuesday, June 28, 2011 8:17:23 AM



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Item ID:	D2940-1	Accept		Setup	Start	
Revision ID:	U/R				Stop	
Item Name:	Support					
Start Date:	6/28/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	7/25/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC14- Inspect Spray Paint  Memo	0.00  0.00					11	08	25 (20)
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>X-tube Ass'y</i>  Memo	0.00  0.00					11	08	25 (20)
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							11/8/25 CL11108125

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 28, 2011 8:17:29 AM

Page 1

Work Order ID: 71308



Parent Item: D2940-1



Parent Item Name: Support


Start Date: 6/28/2011

Required Date: 7/25/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C 02.11.26 Reformat; Added P/O KJ  
IPP Rev:D Added priming as per Rev B 07-04-30 JLM  
IPP E 08.03.19 Re-format Ec verified by DD  
IPP Rev:F 08-10-22 add qc14 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081  D2940-1 TURNING DETAIL		Manufactured	No			110	Each	0.0000	0.5	10			



B.A. 11/18/22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	7130F
<b>Description: Ø3.250 Support</b>		<b>Part Number:</b>	D2940-1
<b>Inspection Dwg: D2940</b>	<b>Rev: B</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	.250	.250	.250	.250
AB	0.490	0.510		0.500	.500	.500	.500	.500
AC	0.140	0.160		0.148	.148	.149	.148	.149
AD	3.510	3.530		3.514	3.515	3.527	3.526	3.526
AE	1.633	1.673		1.662	1.655	1.666	1.661	1.660
AF	1.493	1.513		1.511	1.504	1.507	1.502	1.502
AG	0.040	0.060		0.051	.052	.054	.054	.054
AH	0.188	0.193		0.191	.190	.190	.190	.190
AI	0.140	0.160		0.151	.149	.146	.147	.148
AJ	2.518	2.538		2.525	2.528	2.528	2.528	2.530
AK	0.040	0.060		0.050	.052	.054	.050	.052
AL	0.010	0.020		0.011	.011	.010	.010	.010
AM	0.140	0.160		0.142	.141	.145	.142	.145
AN	0.350	0.450		0.378	.354	.355	.363	.362
AO	0.240	0.260		0.250	.250	.250	.250	.250
AP	0.150	0.170		0.154	.156	.156	.156	.157
AQ	0.053	0.073		0.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.263	.263	.263	.263	.263
AT	0.053	0.073		0.063	.063	.063	.063	.063
AU	4.118	4.138		4.130	4.130	4.128	4.132	4.138
AV								
AW								
Accept/Reject								

Measured by: HA/ *mx* Date: 11/08/17 / 11/08/18

Audited by: *SL* Date: 11-08-23

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>JA</i>



DART AEROSPACE LTD		Work Order:	71308
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.148	.149	.147	.151	.149
AD	3.510	3.530		3.528	3.520	3.523	3.523	3.523
AE	1.633	1.673		1.660	1.656	1.658	1.657	1.660
AF	1.493	1.513		1.501	1.504	1.505	1.505	1.505
AG	0.040	0.060		.054	.056	.057	.050	.054
AH	0.188	0.193		.190	.190	.190	.190	.190
AI	0.140	0.160		.146	.146	.146	.147	.147
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		.050	.051	.051	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.145	.144	.145	.143	.147
AN	0.350	0.450		.362	.365	.364	.375	.375
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.156	.157	.157	.155	.157
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.263	.263	.263	.263	.263
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.130	4.130	4.130	4.130	4.130
AV								
AW								
Accept/Reject								

Measured by:	<i>AK</i>	Date:	11/08/18
Audited by:	<i>SL</i>	Date:	11-08-23
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 71308
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.145	.149	.149	.149	.147
AD	3.510	3.530		3.524	3.525	3.525	3.524	3.524
AE	1.633	1.673		1.656	1.657	1.659	1.656	1.657
AF	1.493	1.513		1.502	1.498	1.504	1.499	1.502
AG	0.040	0.060		.056	.049	.056	.052	.056
AH	0.188	0.193		.190	.190	.190	.190	.190
AI	0.140	0.160		.149	.148	.149	.148	.147
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		.049	.048	.049	.049	.050
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.148	.145	.147	.145	.147
AN	0.350	0.450		.370	.364	.362	.370	.374
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.154	.160	.154	.157	.154
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.263	.263	.263	.263	.263
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.129	4.129	4.129	4.128	4.129
AV								
AW								
Accept/Reject								

Measured by: *AK* Date: 11/08/19

Audited by: *SL* Date: 11-08-23

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
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DART AEROSPACE LTD		Work Order: 71308
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.144	0.146	0.144	0.145	0.146
AD	3.510	3.530		3.525	3.522	3.523	3.525	3.528
AE	1.633	1.673		1.657	1.662	1.662	1.663	1.666
AF	1.493	1.513		1.500	1.507	1.507	1.507	1.510
AG	0.040	0.060		0.052	0.053	0.056	0.053	0.056
AH	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AI	0.140	0.160		0.145	0.143	0.147	0.147	0.147
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		0.053	0.050	0.050	0.050	0.050
AL	0.010	0.020		0.015	0.012	0.012	0.012	0.012
AM	0.140	0.160		0.145	0.145	0.143	0.144	0.144
AN	0.350	0.450		0.373	0.360	0.360	0.360	0.360
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.157	0.156	0.157	0.158	0.156
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.263	0.263	0.263	0.263	0.263
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.127	4.133	4.133	4.130	4.131
AV								
AW								
Accept/Reject								

Measured by: *cmz / ha* Date: 11/08/19

Audited by: *sl* Date: 11-08-23

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
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ECN 11-614

